Thursday, 19/03/2009 11:05:43 AM

User:

Julie Dawson

Process Sheet

Customer Job Number : CU-DAR001 Dart Helicopters Services

S.O. No. :

: 46579

Estimate Number

: 10333

P.O. Number

Prsht Rev.

First Issue

Written By

Previous Run

This Issue

: 19/03/2009

: NC

: //

: 45683

Type

: SMALL /MED FAB

Drawing Revision

Part Number

Drawing Number

Project Number

Drawing Name

Material **Due Date**

: 31/03/2009

: D2530

: N/A

; B

: D2530 REV B

: HANDLE WELDMENT

Qty:

10 Um:

Each

Checked & Approved By

Comment

: Est Rev:E

Removed Purchasing

05-11-07

JLM

Additional Product

Job Number:



Seq. #:

1.0

Machine Or Operation:

Description:

M304TR0750W049

304 RD Tube .750 x .049W



Comment: Qty.:

3.0602 f(s)/Unit Total: 30.6023 f(s)

Material: 304/316 SS Seamless Tubing 0.75" OD x 0.049" wall(M304TR0.750W.049)

2.0

SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2536

2-Deburr

3.0 QC5

Comment: INSPECT WORK TO CURRENT STEP

4.0

D2534

Lock Plate



Comment: Qty.:

2.0000 Each(s)/Unit

Total:

20.0000 Each(s)

Pick:

QTY

Part# D2534 Description

Lock Plate

SMALL & MEDIUM FAB RESOURCE 1

5.0

Page 1

SMALL FAB 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301

Form: rprocess

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		W	ORK ORDER CHA	NGES						
STEP	PR	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mar		roval spector
								r rod wigi		
		·								
	PAR #:	Fault Cate	egory:	NCF	R: Yes I	No DQA:		Date:		
		WORK ORD	ER NON-CONFOR	MANCE	(NCR)				*
STEP	Description of NC					Verificat	ion	Approval	App	rovai
O.L.	Section A	Chief Eng	Action Description Chief Eng	on	Sign & Date	Section	С	Chief Eng	QC In	spector
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	: Res	PAR #: Resolution: STEP Description of NC Section A	PAR #: Fault Cate Resolution: Disposition WORK ORD STEP Description of NC Section A Initial Chief Eng	PROCEDURE CHANGE PROCEDURE CHANGE PAR #: Fault Category: Resolution: Disposition: WORK ORDER NON-CONFOR STEP Description of NC Section A Initial Chief Eng Chief Eng Chief Eng	PAR #: Fault Category: NCF Resolution: Disposition: QA: WORK ORDER NON-CONFORMANCE STEP Description of NC Section A Corrective Action Section B Initial Chief Eng Chief Eng Chief Eng	STEP PROCEDURE CHANGE By PAR #: Fault Category: NCR: Yes Resolution: Disposition: QA: N/C Clo WORK ORDER NON-CONFORMANCE (NCR STEP Description of NC Section A Initial Chief Eng Corrective Action Section B Chief Eng Chief	STEP PROCEDURE CHANGE By Date	STEP PROCEDURE CHANGE By Date Qty PAR #: Fault Category: NCR: Yes No DQA: Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Corrective Action Section B Verification Section C Chief Eng Chief	STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng Aprox Mgr. PAR #: Fault Category: NCR: Yes No DQA: Date: Date: Qty Prod Mgr. PAR #: Fault Category: NCR: Yes No DQA: Date: Da	STEP PROCEDURE CHANGE By Date Qty Chief Eng/Prod Mgr Approval Date: PAR #:

NOTE: Date & initial all entries

Date: Thursday, 19/03/2009 11:05:43 AM User: Julie Dawson **Process Sheet Drawing Name: HANDLE WELDMENT** Customer: CU-DAR001 Dart Helicopters Services Job Number: 46579 Part Number: D2530 Job Number: Seq. #: **Machine Or Operation:** Description: 2-Deburr 6.0 QC9 VISUAL WELDING INSPECTION Comment: VISUAL WELDING INSPECTION 09-04-14 (10) INSPECT WORK TO CURRENT STEP 7.0 QC5 Comment: INSPECT WORK TO CURRENT STEP POWDER COATING 8.0 **Comment: POWDER COATING** Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3 M 105642 START TIME: OVEN TEMPERATURE: FINISH TIME: 9.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 10.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 506 FINAL INSPECTION/W/O RELEASE QC21 11.0 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospac	e Ltd	
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W/O:	•		10/0	NDK ODDED OF	IANOFO				
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DATE	STEP	PR	OCEDURE CHA	NGE '		Ву	Date Qt	y Chief Eng / Prod Mgr	Approval QC Inspector
					·				
Part No	:	PAR #:	Fault Cate	gory:	NC	R: Yes	No DQA: _	Date: _	
	Re	esolution:	Disposition	າ:	QA	: N/C Clo	sed:	Date: _	.,'
NCR:			WORK ORDI	ER NON-CONF	ORMANC	(NCR)		
DATE	STEP	Description of NC		Corrective Action	Section B	T	Verificatio	n Approval	Approval
		Section A	Initial Chief Eng	Action Descri	ption	Sign & Date	Section C	Chief Eng	QC Inspector
								-42	
			[1	1 1

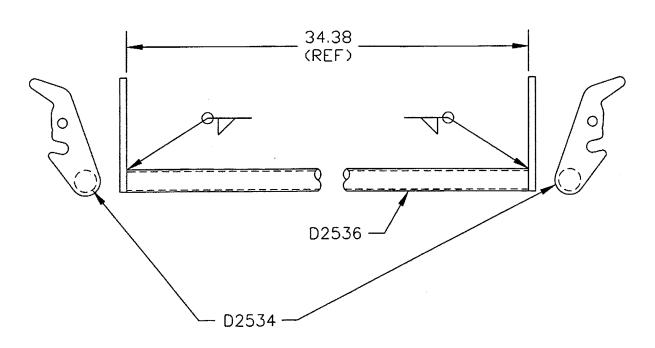
NOTE: Date & initial all entries



DES B	SIGN WILLIAMS	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
	ECKED A	APPROVED,	DRAWING NO.	REV. B
	-#	粉	D2530 SHEET	1 OF 1
DAT	Έ	·	TITLE	SCALE
04	1.12.14		HANDLE WELDMENT	
Α		96.06.18	NEW ISSUE	
R		04 12 14	UPDATE NOTES AND DIMENSIONS	

PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE



D2530 HANDLE WELDMENT

1) WELD PER DART QSI 004

2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3

3) ALL DIMENSIONS ARE IN INCHES

SHOP COPY **RETURN TO** ENGINEERING

4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTEDICONTROLLED COPY

SUBJECT TO AMENDMENT WITHOUT NOTICE